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Charbonneau et al.

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(54) **METHODS OF USING A SUBMERGED COMBUSTION MELTER TO PRODUCE GLASS PRODUCTS**

(58) **Field of Classification Search**

CPC C03B 5/2356; C03B 5/2353; C03B 2211/22; C03B 2211/30; C03B 2211/40

See application file for complete search history.

(71) Applicant: **JOHNS MANVILLE**, Denver, CO (US)

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(72) Inventors: **Mark William Charbonneau**, Lakewood, CO (US); **Bryan Keith Nesti**, Hoschton, GA (US)

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Primary Examiner — Jodi C Franklin

(74) *Attorney, Agent, or Firm* — Robert D. Touslee

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(52) **U.S. Cl.**

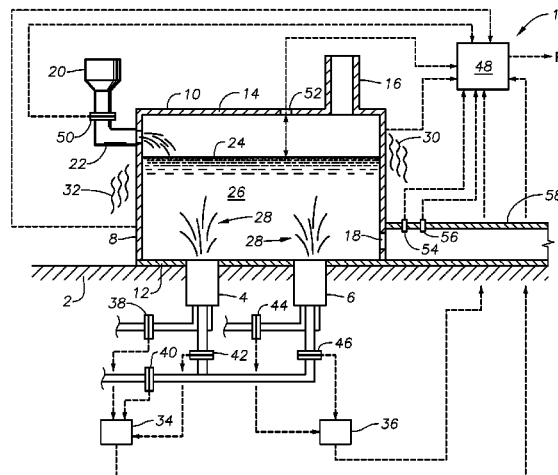
CPC . **C03B 5/24** (2013.01); **C03B 5/04** (2013.01); **C03B 5/2356** (2013.01); **C03B 19/08** (2013.01); **C03B 37/02** (2013.01); **C03B 37/06** (2013.01); **C03B 37/07** (2013.01); **C03B 2211/22** (2013.01); **C03B 2211/23** (2013.01)

(57)

ABSTRACT

A method comprises flowing an oxidant and a fuel into a submerged combustion burner in a glass tank furnace, the glass tank furnace receiving a feed of glass forming material and producing molten glass, the burner and furnace comprising a melting system. The melting system has a variable system vibration and/or oscillation due to the nature of submerged combustion. One method includes predicting a value of at least one property, such as viscosity, of the molten glass using the variable system vibration and/or oscillation.

14 Claims, 7 Drawing Sheets



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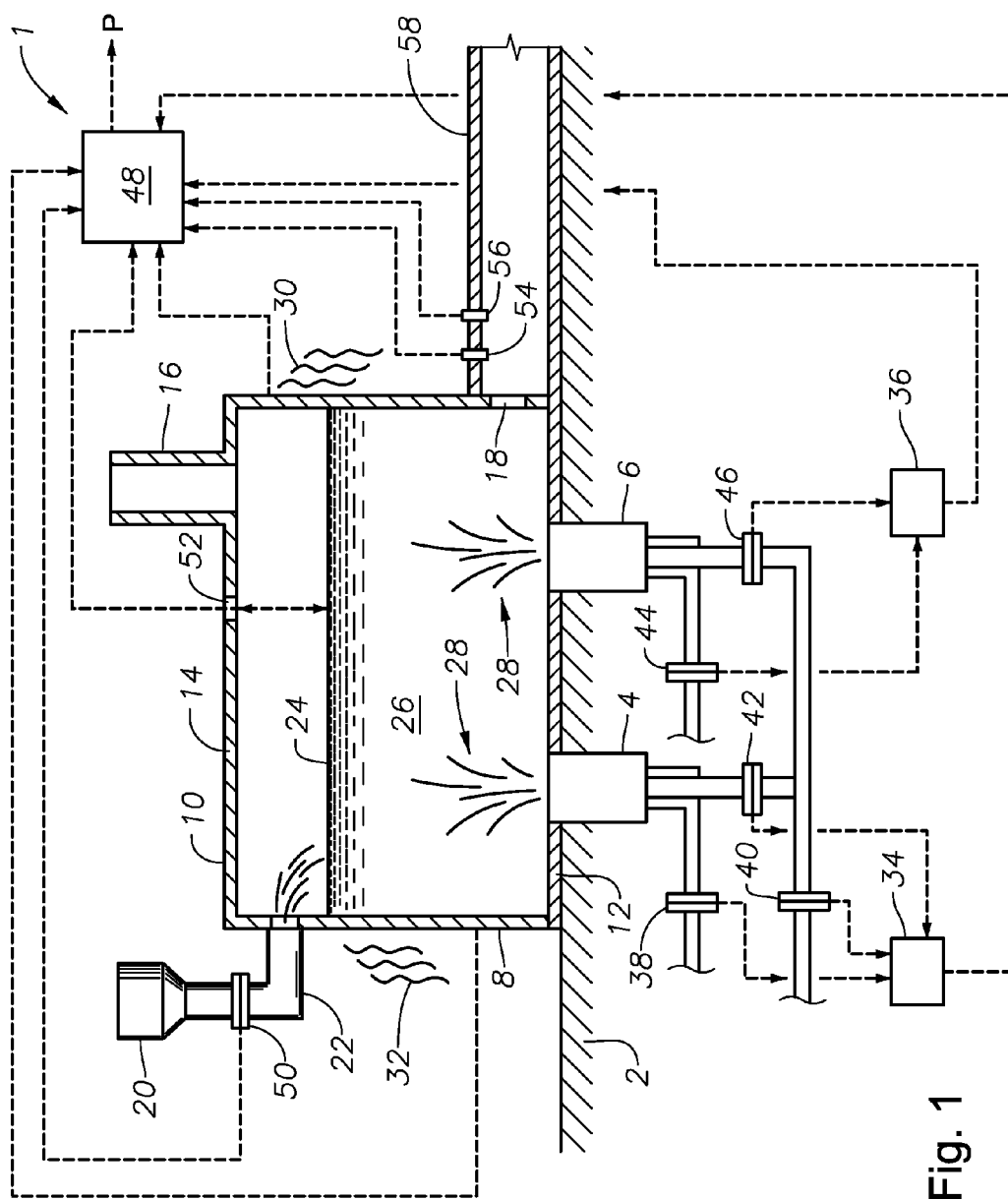
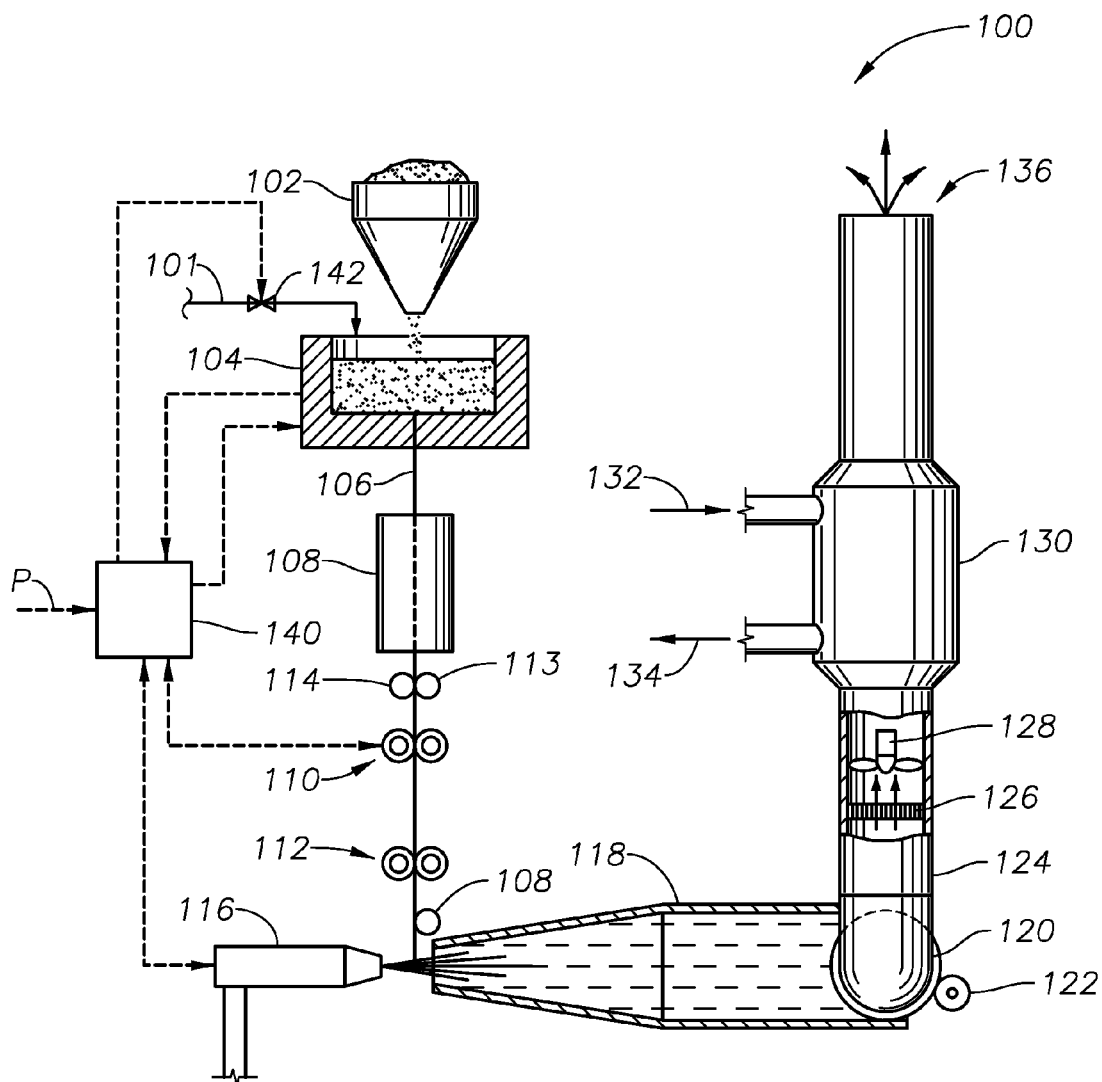


Fig. 2



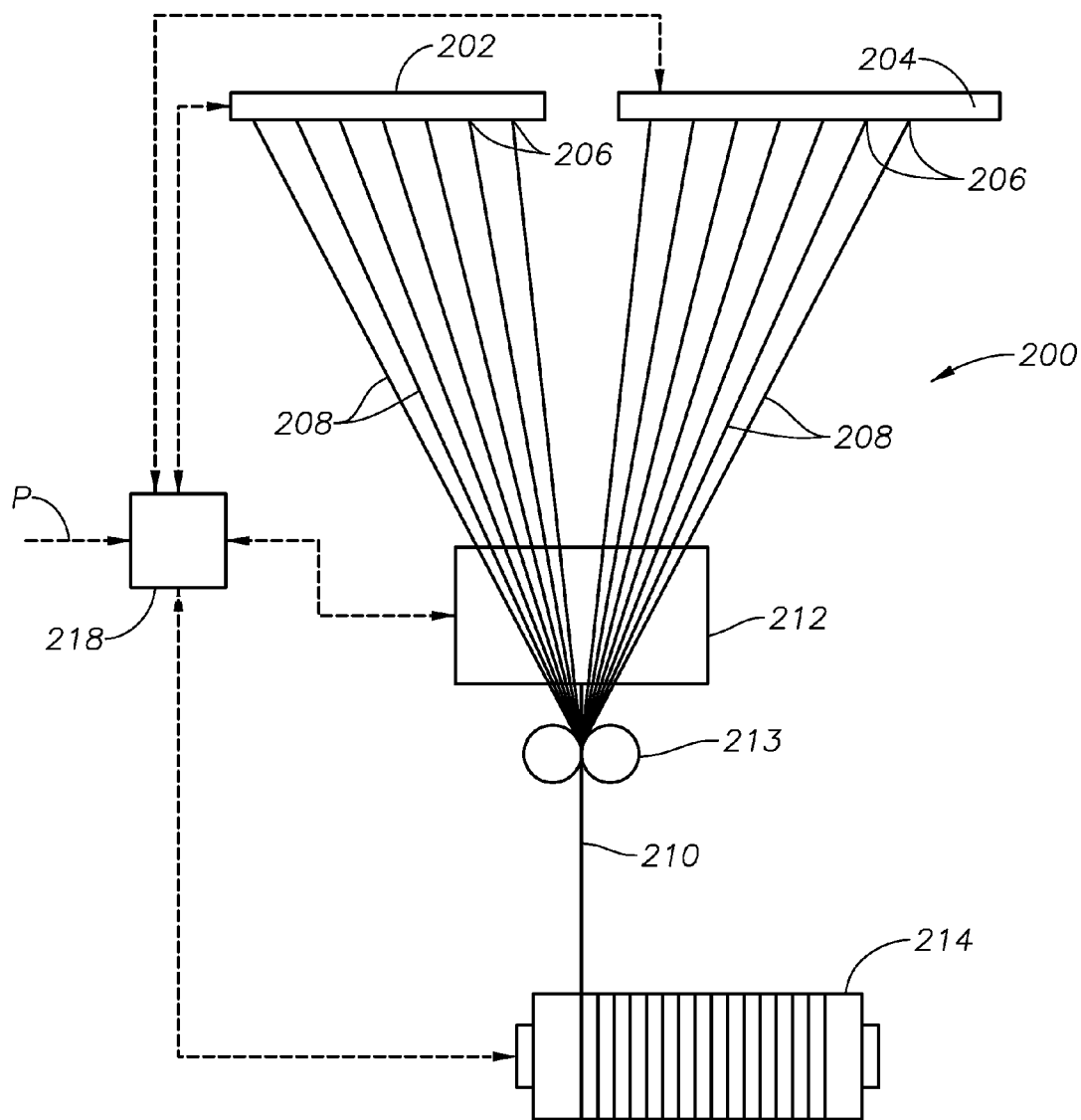


Fig. 3

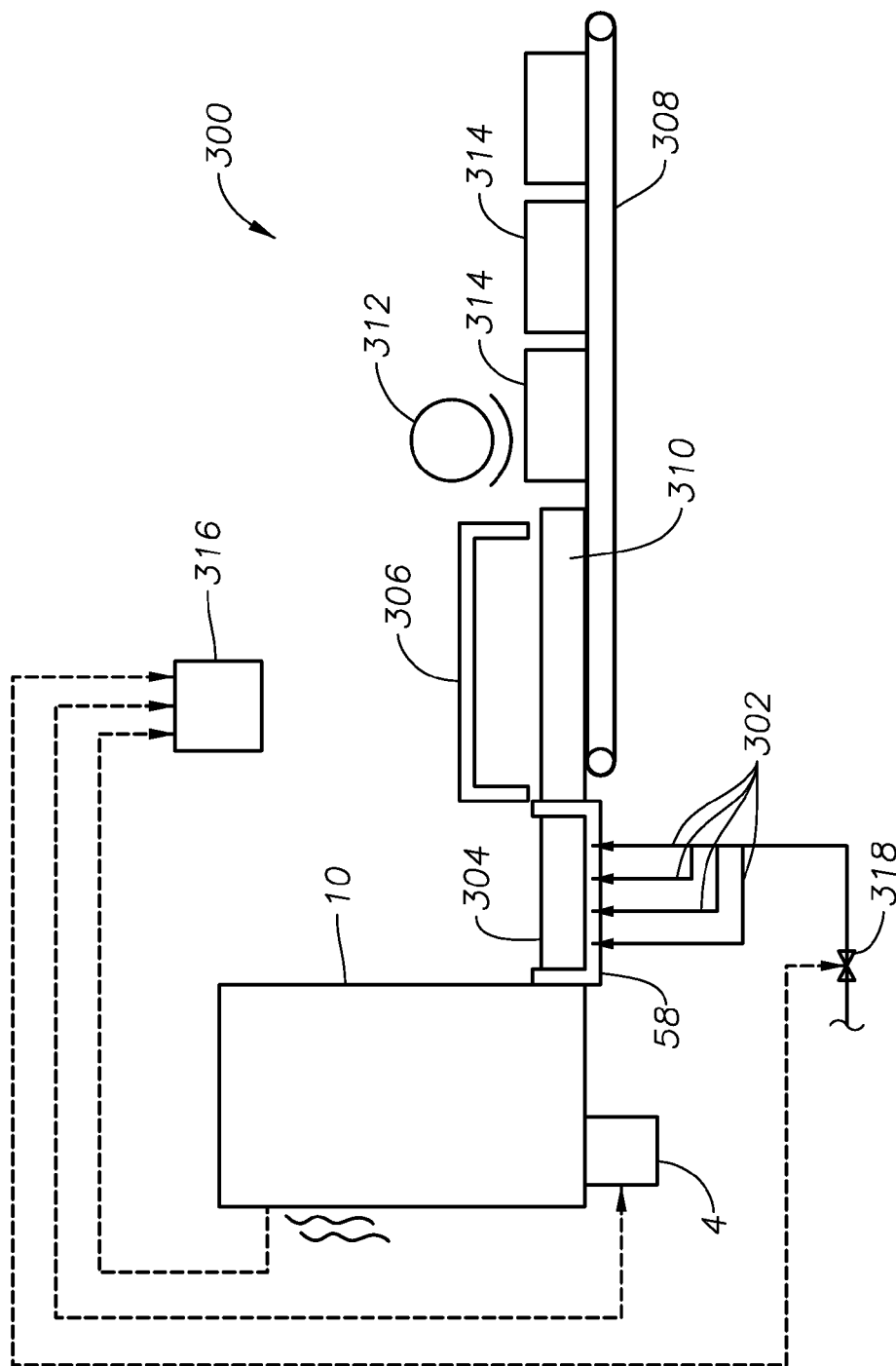


Fig. 4

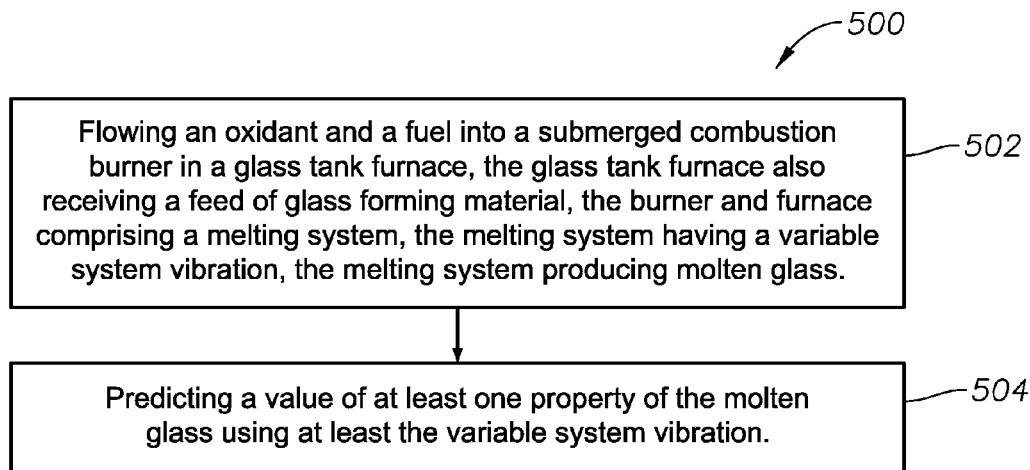


Fig. 5

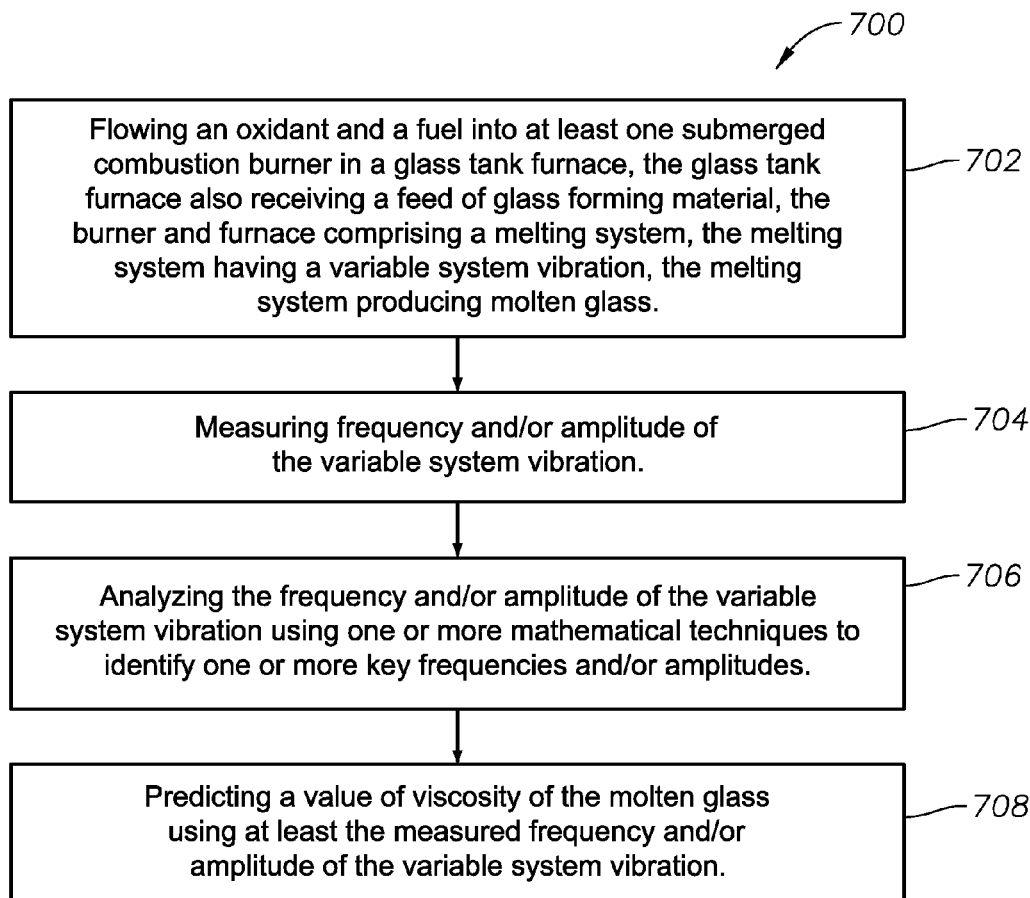


Fig. 7

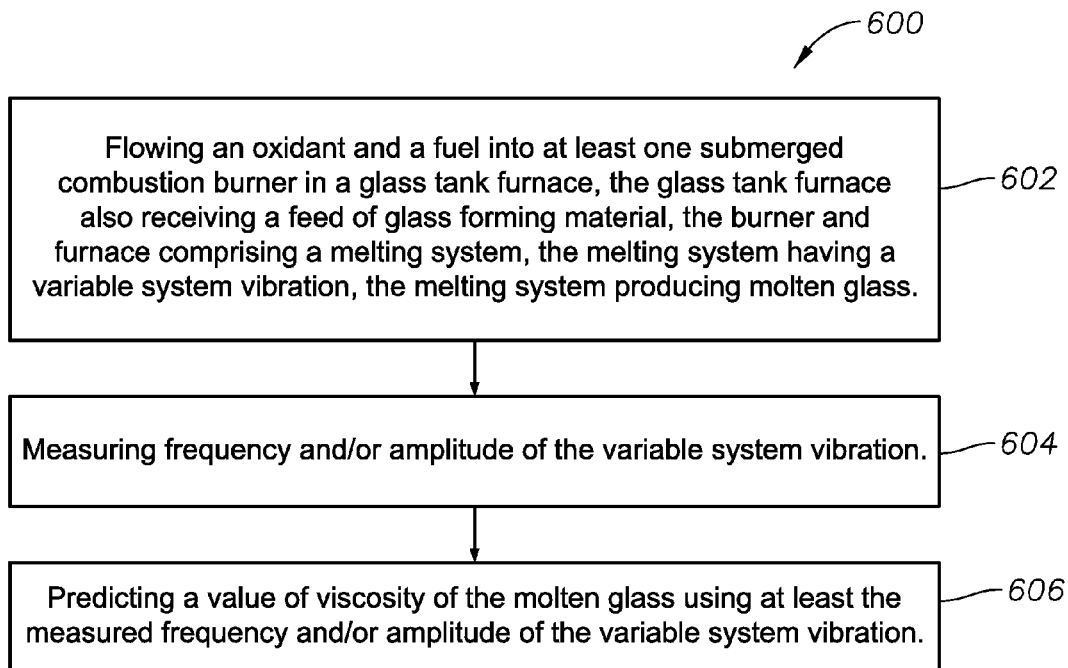


Fig. 6

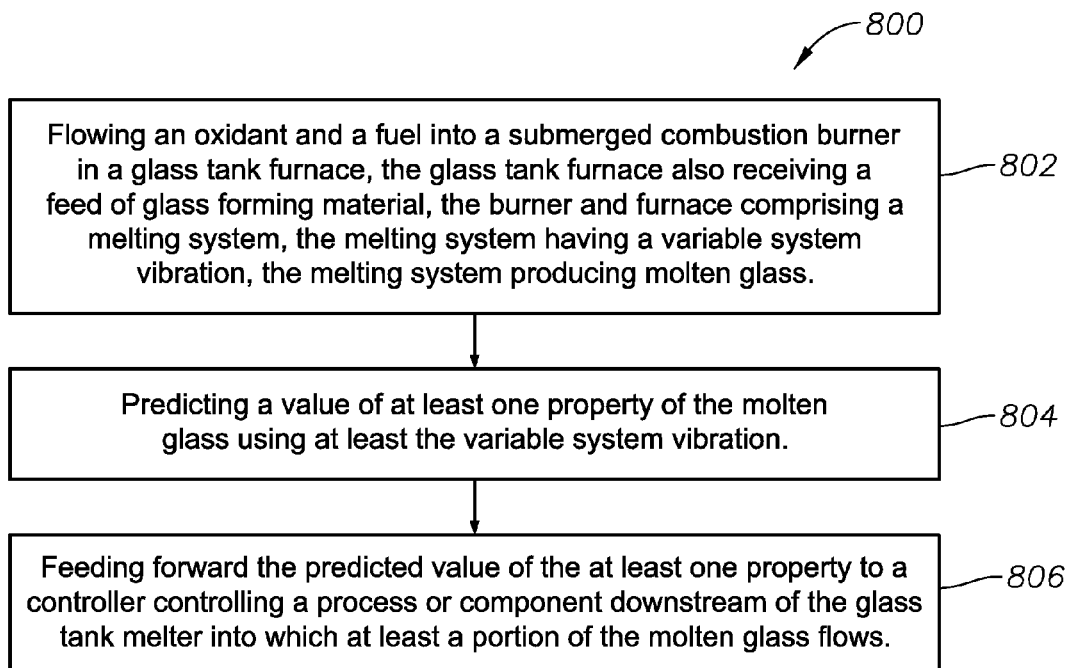


Fig. 8

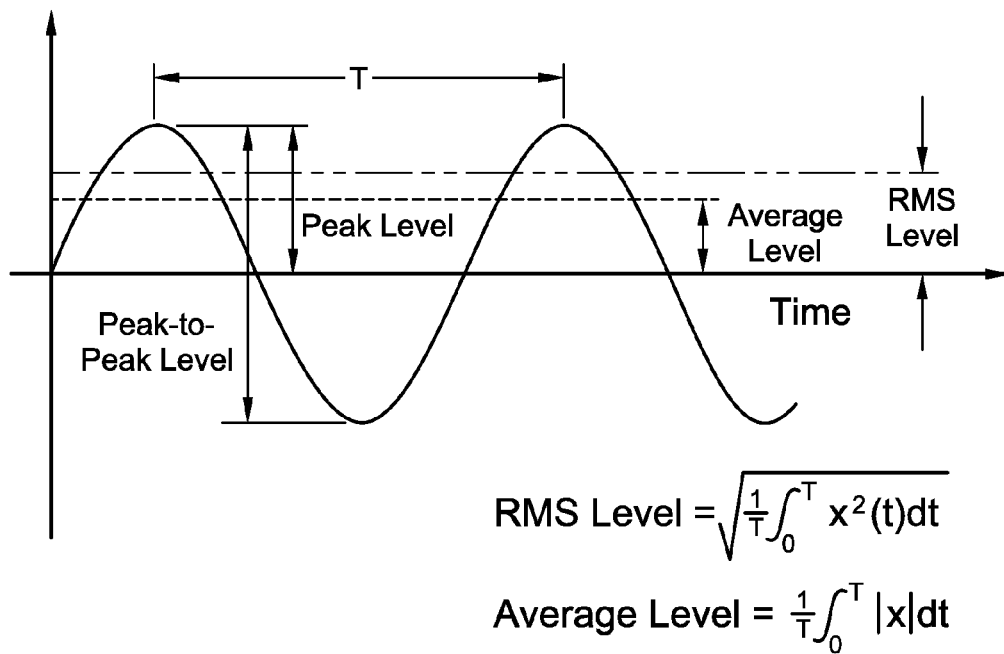


Fig. 9A

(Prior Art)

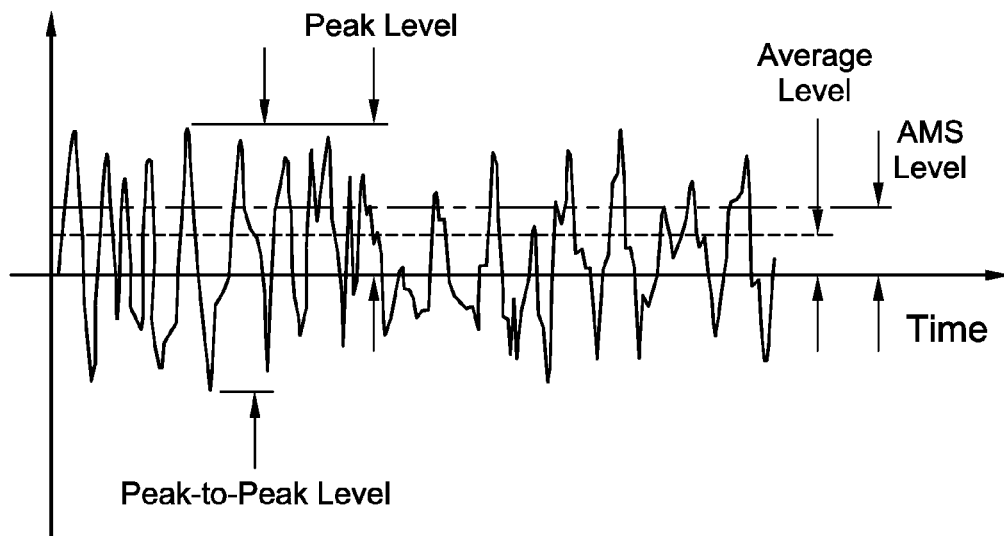


Fig. 9B

(Prior Art)

1

METHODS OF USING A SUBMERGED COMBUSTION MELTER TO PRODUCE GLASS PRODUCTS

CROSS-REFERENCE TO RELATED APPLICATIONS

This application is a division of U.S. application Ser. No. 13/268,065 filed Oct. 7, 2011, now issued Pat. No. 8,973,400. This application is related to assignee's United States non-provisional U.S. application Ser. No. 12/817,754, filed Jun. 17, 2010, now issued U.S. Pat. No. 8,769,992, issued Jul. 8, 2014; Ser. No. 12/888,970, filed Sep. 23, 2010, now issued U.S. Pat. No. 8,650,914, issued Feb. 18, 2014; Ser. No. 13/267,990, filed Oct. 7, 2011; and Ser. No. 13/268,028, filed Oct. 7, 2011, now issued U.S. Pat. No. 8,875,544, issued Nov. 4, 2014, all of which are incorporated herein by reference.

BACKGROUND INFORMATION

1. Technical Field

The present disclosure relates generally to the field of submerged combustion glass melters and methods of use.

2. Background Art

Submerged combustion melters are known for producing molten glass. The nature of submerged combustion melters and their operation cause a perceptible and measurable vibration and/or oscillation in the system.

It would be an advance in the submerged combustion glass melting art to develop methods of using the vibration and/or oscillation of the submerged combustion melter, either alone or in combination with other system parameters, to predict properties of the molten glass or other material melted within the melter, particularly in situations where melter feeds, fuels, and/or oxidants are changing or expected to change.

SUMMARY

In accordance with the present disclosure, methods of using vibrations and/or oscillations of a submerged combustion melter are described that may allow predicting or tuning of one or more molten or finished glass parameters.

A first aspect of the disclosure is a method, the method comprising:

a) flowing an oxidant and a fuel into a submerged combustion burner in a glass tank furnace, the glass tank furnace also receiving a feed of glass forming material, the burner and furnace comprising a melting system, the melting system having a variable system vibration, the melting system producing molten glass; and

b) predicting a value of at least one property of the molten glass using at least the variable system vibration.

A second aspect of the disclosure is method of producing molten glass using submerged combustion, the method comprising:

a) flowing an oxidant and a fuel into at least one submerged combustion burner in a glass tank furnace, the glass tank furnace also receiving a feed of glass forming material, the burner and furnace comprising a melting system, the melting system having a variable system vibration, the melting system producing molten glass;

b) measuring frequency and/or amplitude of the variable system vibration; and

2

b) predicting a value of viscosity of the molten glass using at least the measured frequency and/or amplitude of the variable system vibration.

A third aspect of the disclosure is a method of producing molten glass using submerged combustion, the method comprising:

a) flowing an oxidant and a fuel into at least one submerged combustion burner in a glass tank furnace, the glass tank furnace also receiving a feed of glass forming material, the burner and furnace comprising a melting system, the melting system having a variable system vibration, the melting system producing molten glass;

b) measuring frequency and/or amplitude of the variable system vibration;

c) analyzing the frequency and/or amplitude of the variable system vibration using one or more mathematical techniques to identify one or more key frequencies and/or amplitudes; and

b) predicting a value of viscosity of the molten glass using at least the measured frequency and/or amplitude of the variable system vibration.

Certain methods within the disclosure include feeding forward the predicted value of the at least one property to a controller controlling a process or component downstream of the glass tank melter into which at least a portion of the molten glass flows.

Methods of the disclosure will become more apparent upon review of the brief description of the drawings, the detailed description of the disclosure, and the claims that follow.

BRIEF DESCRIPTION OF THE DRAWINGS

The manner in which the objectives of the disclosure and other desirable characteristics can be obtained is explained in the following description and attached drawings in which:

FIG. 1 is a schematic side-elevation view, partially in cross-section of a submerged combustion melter and method of controlling same and/or predicting a parameter of the melt in accordance with the present disclosure;

FIGS. 2, 3 and 4 are schematic side elevation views, partially in cross-section, of downstream systems and methods that may be controlled using a predicted value of a parameter from the system and method of FIG. 1;

FIGS. 5, 6, 7 and 8 are logic diagrams of four methods in accordance with the present disclosure; and

FIGS. 9A and 9B are prior art schematic representations of vibration that may be useful in understanding aspects of the present disclosure.

It is to be noted, however, that FIGS. 1-4 of the appended drawings are not to scale and illustrate only typical embodiments of this disclosure, and are therefore not to be considered limiting of its scope, for the disclosure may admit to other equally effective embodiments.

DETAILED DESCRIPTION

In the following description, numerous details are set forth to provide an understanding of the disclosed methods and systems for carrying out the methods. However, it will be understood by those skilled in the art that the methods and systems may be practiced without these details and that numerous variations or modifications from the specifically described embodiments may be possible and are deemed within the claims or claimable subject matter in this or subsequent patents. All United States (U.S.) published patent applications and U.S. Patents referenced herein are

hereby explicitly incorporated herein by reference. In the event definitions of terms in the referenced patents and applications conflict with how those terms are defined in the present application, the definitions for those terms that are provided in the present application shall be deemed controlling.

The term “fuel”, according to this disclosure, means a combustible composition comprising a major portion of, for example, methane, natural gas, liquefied natural gas, propane, atomized oil or the like (either in gaseous or liquid form). Fuels useful in the disclosure may comprise minor amounts of non-fuels therein, including oxidants, for purposes such as premixing the fuel with the oxidant, or atomizing liquid fuels. As used herein the term “fuel” includes gaseous fuels, liquid fuels, flowable solids, such as powdered carbon or particulate material, waste materials, slurries, and mixtures or other combinations thereof. When the fuel comprises gaseous fuel, the gaseous fuel may be selected from the group consisting of methane, natural gas, liquefied natural gas, propane, carbon monoxide, hydrogen, steam-reformed natural gas, atomized oil or mixtures thereof.

“Oxidant” means air, or compositions comprising the same molar concentration of oxygen as air, while the term “oxygen” means a gas with an oxygen molar concentration of at least 50%. Such oxidants include oxygen-enriched air containing at least 50% vol., oxygen such as “industrially” pure oxygen (99.5%) produced by a cryogenic air separation plant or non-pure oxygen produced by an adsorption process or membrane permeation process (about 90% vol. oxygen or more).

Submerged combustion melters useful in methods and systems of the present disclosure may be comprised of metal, ceramic, ceramic-lined metal, or combination thereof. Suitable metals include stainless steels, for example, but not limited to, 306 and 316 steel, as well as titanium alloys, aluminum alloys, and the like.

In all embodiments of the disclosure the sources of oxidant and fuel may be one or more conduits, pipelines, storage facility, cylinders, or, in embodiments where the oxidant is air, ambient air. Oxygen-enriched oxidants may be supplied from a pipeline, cylinder, storage facility, cryogenic air separation unit, membrane permeation separator, or adsorption unit such as a vacuum swing adsorption unit. Certain burner and melter embodiments may comprise a source of oxidant fluidly connected to the second conduit for routing the oxidant to the primary annulus, wherein the oxidant is selected from the group consisting of air and oxygen-enriched air, and a source of fuel fluidly connected to the second end of the first conduit for routing the fuel to the longitudinal bore of the first conduit.

In certain methods of the disclosure the predicted and/or controlled property of the molten glass may be a physical property selected from the group consisting of boiling point, color, concentration, density, electrical conductivity or impedance, flexibility, flow rate, mass, melting point, pressure, specific heat, resistivity, temperature, tension, velocity, viscosity, and volume.

In certain methods the predicting step may comprise measuring the depth or level of molten glass in the glass tank furnace, and using the measured depth or level in the predicting.

Certain method embodiments may comprise feeding forward the predicted value of the at least one property to a controller controlling a process or component downstream of the glass tank melter into which at least a portion of the molten glass flows.

Certain method embodiments may comprise using the predicted value of the at least one property of the melt to control the glass tank furnace.

Certain method embodiments may comprise feeding forward the predicted value of the at least one property of the melt to a controller controlling a process or component downstream of the glass tank melter into which at least a portion of the molten glass flows and using the predicted value of the at least one property to control the glass tank furnace.

Certain method embodiments may comprise measuring frequency and/or amplitude of the variable system vibration. Certain methods may comprise analyzing the frequency and/or amplitude of the variable system vibration using one or more mathematical techniques to identify one or more key frequencies and/or amplitudes. Certain methods may comprise measuring at least one other system property selected from the group consisting of flow rate of oxidant, flow rate of fuel, flow rate of glass forming material, flow rate of molten glass, glass tank furnace pressure, height or depth of molten glass in the glass tank furnace, and combinations thereof. In certain methods the predicting may comprise using a technique selected from the group consisting of linear regression, non-linear modeling, and neural net modeling.

Certain method and systems embodiments of the disclosure may be controlled by one or more controllers. For example, burner flame temperature may be controlled by monitoring one or more parameters selected from velocity of the fuel, velocity of the primary oxidant, mass flow rate of the fuel, mass flow rate of the primary oxidant, energy content of the fuel, temperature of the fuel as it enters the burner, temperature of the primary oxidant as it enters the burner, temperature of the effluent, pressure of the primary oxidant entering the burner, humidity of the oxidant, burner geometry, combustion ratio, and combinations thereof. Exemplary methods and systems of the disclosure may comprise one or more slave combustion controller which receives one or more input parameters selected from velocity of the fuel, velocity of the primary oxidant, mass flow rate of the fuel, mass flow rate of the primary oxidant, energy content of the fuel, temperature of the fuel as it enters the burner, temperature of the primary oxidant as it enters the burner, pressure of the oxidant entering the burner, humidity of the oxidant, burner geometry, oxidation ratio, temperature of the effluent and combinations thereof, and may employ a control algorithm to control combustion temperature based on one or more of these input parameters. One or more of the slave combustion controllers may feed one or more outputs to one or more master controllers that receive measurements indicative of one or more melter vibrations and/or oscillations, the master controller then predicting a parameter of the melt for feeding forward to another process, or controlling the melter, or both.

Referring now to the figures, FIG. 1 is a side-elevation view, partially in cross-section, of a submerged combustion melter system and method embodiment 1 in accordance with the present disclosure, including a glass tank furnace or melter 10 positioned on a plant floor or other surface 2, including two burners 4 and 6, one or both of which may be of the adjustable burner type described in assignee's co-pending U.S. patent application Ser. No. 13/268,028, filed Oct. 7, 2011, now U.S. Pat. No. 8,875,544, comprising first and second conduits configured to form a primary annulus between the external surface of the first conduit and the internal surface of the second conduit, and an adjustable structure comprising a generally cylindrical central hub

adjustable axially in relation to and removably attached to the first end of the first conduit, the hub defining a central passage and one or more non-central through passages. More than or less than two burners may be used, as well as burners of other designs, as long as one submerged burner is present. Metter **10** includes sidewalls **8**, a floor **12**, a roof **14**, an exhaust chute **16**, and a glass melt exit **18**. A glass-forming material feed bin **20** may be attached to melter sidewall **8** via a conduit **22**. One or more burners **4**, **6** may be in one or more sidewalls **8**, as long as the flame and/or products of combustion **28** emanate below surface **24** of melt **26**. Burners **4**, **6** may be positioned in a sidewall **8** or floor **12** of submerged combustion melter **10** such that the longitudinal axis of the burners makes an angle to a side panel **8** or floor **12** of melter **10** ranging from about 30 to about 90 degrees. Sidewalls **8**, floor **12**, and roof **14** are typically composed of ceramic or other refractory material. Other melter designs, having other feed arrangements, burner arrangements, and wall designs, such as disclosed in assignee's co-pending application Ser. No. 12/817,754, filed Jun. 17, 2010, now U.S. Pat. Nos. 8,769,992; 12/888,970, filed Sep. 23, 2010, now U.S. Pat. Nos. 8,650,914; and 13,267,990, 13,268,028, 13/268,098, and 13/268,130 all filed Oct. 7, 2011, and now U.S. Pat. Nos. 8,997,525, 8,875,544, 8,707,740, and 9,021,838, respectively and U.S. Pat. No. 7,273,583, are considered within the present disclosure.

Still referring to FIG. 1, the inventors herein have discovered that submerged combustion melter systems such as illustrated schematically in embodiment 1 of FIG. 1 may exhibit vibration and/or oscillation depending on their configuration, as indicated in FIGS. 1 at **30** and **32**. The inventors herein have also discovered that this vibration and/or oscillation may be used for one or more useful purposes, such as controlling (or contributing to the control of) submerged combustion melter **10**, and/or controlling or contributing to the control of one or more processes or systems downstream of melter **10**. As a non-limiting example, embodiment 1 illustrated schematically in FIG. 1 employs burner controllers **34**, **36**, which may be programmable logic controllers or other controllers. In this embodiment, controller **34** receives signals (signals, which may be wired or wireless, are indicated by dashed lines) from oxidant flow meter **38** and fuel flow meters **40**, **42**, while controller **36** receives signals from oxidant flow meter **44** and fuel flow meter **46**. Controllers **34** and **36** may send control signals to control valves (not illustrated) controlling flow of fuel (such as natural gas) and oxidant (such as oxygen) to burners **4** and **6**. A main or primary, or master controller **48** may receive one or signals indicating vibration and/or oscillation of one or more locations of melter **10**. Master controller **48** may also receive various other signals, for example from burner controllers **34**, **36**; a glass forming material feed flow meter **50**; from a molten glass depth or level sensor **52**; from a melt temperature sensor **54**; and/or from a melt flow rate sensor **56** in a forehearth **58**. A predicted value P of the melt may then be computed or estimated mathematically by controller **48** and used for one or more purposes, as noted further herein. It will be understood that many control variations are possible. For example, controller **48** may receive signals directly from flow meters **38**, **40**, **42**, **44**, and **46** rather than through burner controllers **34**, **36**. In the figures, direction of flow of signal is indicated by arrows. Indication of an arrow in one direction does not necessarily mean signals cannot be sent the opposite direction. Double headed arrows, while generally indicating that signals may be sent and received

between two components, does not mean that signals are always sent between those components in both directions.

Referring now to FIG. 2, FIG. 2 is a schematic process flow diagram of a prior art air-fuel fiberization system and method embodiment **100** that may benefit from the systems and methods of the invention. Molten glass **101** from forehearth **58** of embodiment 1 may be transported to a heated pot **104**. Optionally, glass marbles may be transported to distribution hopper **102** and then into heated pot **104**, which then melts the marbles into molten glass. Molten glass **101** and/or marbles may be transported to feed hopper **102** and/or heated pot **104** with a distribution manifold to a plurality of heated pots **104**, the feed rate to heated pots **104** being a function of pot temperature and roller 110 rpm. Heated pot **104**, sometimes referred to as the marble pot, may typically comprise a metallic cylinder heated with a heating jacket using premixed natural gas burners on its side walls. The bottom of marble pot **104** may be formed from a metal alloy comprising multiple holes ranging from about 0.05 inch to 0.5 inch in diameter, depending on the glass fiber product being made, through which the molten glass is drawn into primary fibers **106** (only one primary fiber is shown). Primary fibers **106** may be pulled and directed by rollers **112** and by fiber guides **113** and **114** through a heat containment shield **108**. Shield **108** may extend in space between the bottom of marble pot **104** to the top of the first set of rollers **110**, and functions to control the cooling rate of the primary fiber. The objective is to keep the primary fiber as hot as possible without damaging roller pad material in the rollers. In addition to the heat shield, heat sources, such as infrared sources may be placed in the spaces before rollers **110** and **112** or after the rollers.

A fiberization burner **116**, which may be an air-fuel or oxy-fuel burner, functions to produce a hot flame at a controlled temperature, velocity, and oxidation state. The glass fiber product to be manufactured is a function of the mass flow rate of the glass, the primary glass fiber diameter, the flame temperature produced by burner **116**, the slot size and pressure inside of burner **116**, and the product code fiber diameter. Benefits of using oxygen or oxygen-enriched air as an oxidant in fiberization burners may include higher flame temperature fiberization, which may lead to increased fiber tensile strength, longer fibers, and reduce production or elimination of shot, or looser process control to avoid producing shot. Fluctuations in humidity may be reduced, and variation in fiber quality may be reduced.

In accordance with the present disclosure, a controller **140** may receive a signal P from controller **48** controlling melter system and method **1** (FIG. 1). Controller **140** may also receive signals from heated pot **104**, pull rollers **110**, and/or burner **116**, and may send one or more control signals to a valve **142**, heated pot **104**, pull rollers **110**, and/or burner **116**.

In the system and method illustrated schematically in FIG. 2, a collection chamber **118** comprising a generally cylindrical chute collects short fibers and entrains air into chamber **118** to rapidly cool the molten fibers. The fiber are then routed to a larger section of chamber **118** where at the far end a fiber pickup drum **120** collects the fibers, where a secondary fiber pickup apparatus **122**, such as vacuum ducting or a roller, removes the fibers. Pickup drum **120** is typically a rotating perforated steel cylinder with a filter material suitable for collecting fibers secured to the outer surface of the cylinder, with aide of negative pressure on the inside of drum **120**. Combustion gases, any particulates, and excess air (in the prior art process, and in addition excess oxygen in systems and methods of the present disclosure)

pass through drum **120** through ducting **124** and flow through a particulate removal device **126**, with aide of an exhaust fan **128**. A heat exchanger **130** may be used to cool exhaust gases, which exit to atmosphere at **136**. In prior art system and methods using air-fuel combustion, cool air **132** is used to cool the exhaust, resulting in warmed air **134** of low grade heat content, largely unusable in heat recovery. However, with the higher temperatures experienced in oxy-fuel combustion if used in fiberization burner **116**, this heat may be recovered and used in various ways. In light of the higher fiberization burner flame temperatures involved when using oxy-fuel fiberization burners (from about 2200 to about 3200° F. as opposed to 1900° F. for air-fuel fiberization flame temperatures), opportunities exist also for heat recovery and energy savings, as further explained in assignee's U.S. Pat. No. 7,802,452

FIG. 3 is an illustration of a method and system **200** of making continuous fibers in accordance with the present disclosure. Several different processes may be used to form fibers, depending on the type of fiber. Textile fibers may be formed from molten glass directly from the furnace, or the molten glass may be fed first to a machine that forms glass marbles of about 0.62 inch (1.6 cm) in diameter, as alluded to herein. These marbles allow the glass to be inspected visually for impurities. In both the direct melt and marble melt process, the glass or glass marbles may be fed through electrically heated bushings (also called spinnerets) **202**, **204**. Bushing may be made of platinum or metal alloy, with anywhere from 200 to 3,000 very fine orifices **206**. The molten glass passes through orifices **206** and comes out as fine filaments **208**, as indicated schematically in FIG. 3. Multiple fine or primary filaments **208** may be collected into a product filament **210** by a fiber gatherer (in some embodiments binder applicator) **212** and rollers **213**, and product filament **210** may be wound on a winder **214**. A controller **218** may be used to control production of continuous fibers in embodiment **200** and similar embodiments. Controller **218** may receive a predicted value P from controller **48** of system and method embodiment 1 (FIG. 1), as well as signals representative of temperature of bushings **202**, **204**, pull rate of rollers **213**, rate of winding of winder **214**, and/or other parameters.

FIG. 4 illustrates another non-limiting system embodiment **300** in accordance with the present disclosure. In embodiment **300**, initial foamy molten glass **304** from one or more submerged combustion melters **10** is discharged into one or more refractory or refractory-lined channels **58** where the bubble size in the molten glass is increased through means of additional air or other gaseous injection through one or more gas injectors **302**, four being illustrated in this embodiment, to form a lower density, foamy molten glass through increased bubble size, and to control product density, bubble size, and gases contained within the bubbles. This lower density glass is discharged to a cooling and annealing Lehr **306** on a conveyor **308** for thermal treatment into glass **310**, and subsequent shaping into final products **314** of various shapes, for example by cutting equipment **312**. Lehr **306** may not be necessary in all embodiments. In embodiment **300**, a controller **316** may receive a sensed signal indicative of vibration and/or oscillation of melter **10**, as well as other signals, such as oxidant and fuel flow rates to burner **4**, flow of gas to refractory channel **58**, level in melter **10**, and so on. Controller **316** may calculate an actual or predicted value of a parameter of foamy melt **304** exiting melter **10**, for example density, which value may be used to control the system and method, for example, amount of gas

injected into the foamy melt using a valve **318** or other flow controller, burner fuel or oxidant flow rates, and the like.

Flow rates and composition of injected gas will depend upon the desired final foamed glass product density, and the flow rate of molten glass, but generally the flow rate of gas will range from about 0 to about 0.1 scf/lb. (0 to about 6250 cm³/kg) of molten glass product/injector, or from 0 to about 0.03 scf/lb. (0 to about 1875 cm³/kg) of molten glass product/injector. The number of and position of gas injectors **302** may vary, with lower number of injectors generally meaning their diameter would increase to deliver an equivalent amount of gas. Some of the injectors may be floor (bottom) mounted while some may be side-wall mounted, or all may be floor-mounted or all may be side-wall mounted. Gas injectors **302** may be positioned uniformly or non-uniformly. Flow of gas may be pulsed or non-pulsed. The flow rate of molten glass through channel **58** will in turn depend on the dimensions of channel **58**, size of melter **10**, temperature of the melt, viscosity of the melt, and like parameters, but in general the flow rate of molten glass in channel **58** may range from about 0.5 lb/min to over 5000 lbs/min (from about 0.23 kg/min to over 2300 kg/min), or from about 10 lbs/min to about 500 lbs/min (from about 4.5 kg/min to about 227 kg/min), or from about 100 lbs/min to 300 lbs/min (from about 45 kg/min to about 135 kg/min).

Temperature of the injected gas through gas injectors **302** is not critical, but higher temperature gases may increase the ability of the gas to disperse in the foamy molten glass and cause less heat loss in the system, while cooler gases may require that the melter and possibly the Lehr use more energy in the melting and annealing steps. In certain embodiments the injected gas may actually be used to control cooling of the foamy molten glass.

Pressure of the injected gases is also not critical, except that the pressure at the tip of the gas injectors need be higher than the local pressure of the foamy molten glass in channel **58**. Too high gas injection pressures may cause unnecessary and undesired "belching" of the foamy molten glass, while too low gas injection pressure may cause the gas to be held up by the foamy molten glass, or not enter the foamy molten glass in channel **58**. In worse cases the foamy molten glass might enter the gas injectors, which is undesired.

Gas injectors **302** may simply be open-ended pipes protruding through the bottom, the sides, or both of channel **58**, or may be specifically designed injectors, such as pipe-in-pipe designs having water-cooled injection tubes, nozzles, and the like. The injectors themselves may be straight, angled, or curved conduits, and they may inject gas perpendicular to the bottom or sidewalls of channel **58**, or may inject gas at an angle to the bottom and/or sidewalls.

Channel **58** and gas injectors **302** may be made from stainless steel, ceramic material (for example zirconia and the like), or other heat-resistant material, and combinations thereof (for example ceramic inserts in stainless steel tubes). Channel **58** may have any lateral shape, such rectangular, oval, round, and the like. Depth of channel **58** may vary, but exemplary embodiments may have a depth that is commensurate with melter **10** depth, and such that the foamy molten glass will be able to move onto conveyor **308** and into Lehr **306**.

FIGS. 5, 6, 7, and 8 are logic diagrams of four method embodiments in accordance with the present disclosure. The method of embodiment **500** of FIG. 5 comprises flowing an oxidant and a fuel into a submerged combustion burner in a glass tank furnace, the glass tank furnace also receiving a feed of glass forming material, the burner and furnace comprising a melting system, the melting system having a

variable system vibration, the melting system producing molten glass, box 502; and predicting a value of at least one property of the molten glass using at least the variable system vibration, box 504.

Another method of this disclosure is presented in the logic diagram of FIG. 6 as embodiment 600. Embodiment 600 is a method of producing molten glass, and comprises the steps of flowing an oxidant and a fuel into at least one submerged combustion burner in a glass tank furnace, the glass tank furnace also receiving a feed of glass forming material, the burner and furnace comprising a melting system, the melting system having a variable system vibration, the melting system producing molten glass, box 602. Method embodiment 600 then comprises measuring frequency and/or amplitude of the variable system vibration, box 604, then predicting a value of viscosity of the molten glass using at least the measured frequency and/or amplitude of the variable system vibration, box 606.

Yet another method of this disclosure is presented in the logic diagram of FIG. 7 as embodiment 700. Embodiment 700 is a method of producing molten glass, and comprises the steps of flowing an oxidant and a fuel into at least one submerged combustion burner in a glass tank furnace, the glass tank furnace also receiving a feed of glass forming material, the burner and furnace comprising a melting system, the melting system having a variable system vibration, the melting system producing molten glass, box 702. Method embodiment 700 then comprises measuring frequency and/or amplitude of the variable system vibration, box 704, then analyzing the frequency and/or amplitude of the variable system vibration using one or more mathematical techniques to identify one or more key frequencies and/or amplitudes, box 706. Method 700 then comprises predicting a value of viscosity of the molten glass using at least the measured frequency and/or amplitude of the variable system vibration, box 708.

Another method of this disclosure is presented in the logic diagram of FIG. 8 as embodiment 800. Embodiment 800 is a method of producing molten glass, and comprises the steps of flowing an oxidant and a fuel into a submerged combustion burner in a glass tank furnace, the glass tank furnace also receiving a feed of glass forming material, the burner and furnace comprising a melting system, the melting system having a variable system vibration, the melting system producing molten glass, box 802, then predicting a value of at least one property of the molten glass using at least the variable system vibration, box 804. Method embodiment 800 includes feeding forward the predicted value of the at least one property to a controller controlling a process or component downstream of the glass tank melter for making glass objects, box 806. The process or component downstream of the glass tank melter may be selected from the group consisting of a continuous glass fiber production system, a staple fiber attenuation system, a system for producing shaped glass objects, or other downstream component, system or method. In certain embodiments the system for producing shaped glass objects may comprise a system for producing foamed glass objects.

In operation of burners of the disclosure, in exemplary embodiments oxidant may be fed to the primary annulus, and a fuel to the longitudinal bore of the first conduit. An inorganic glass-forming material is charged to the melter. The mass flow rate of the inorganic material, for example glass, is a function of the composition of the feed material, desired composition, viscosity, and temperature of the molten glass, the flame temperature of the burner(s), the burner geometry, for example burner exit, nozzle exit, and non-

central passages sizes, the pressure in the mixing region of the burner, and other parameters. The process operating conditions are generally not independent values but have some degree of interaction. Oxygen-enhanced oxidant/fuel melting is markedly different than the traditional air-fuel melting processes. The general principle is to operate combustion in the mixing region of the burner in a manner that replaces some of the air with a separate source of oxygen. The overall combustion ratio may not change. The process of combining fuel and oxygen-enriched oxidant will, in most embodiments, primarily occur in the mixing region, after the gases have passed over a flame arrestor safety device. Varying the oxygen content of the oxidant can control the flame temperature of the combustion gases.

The total quantities of fuel and oxidant used by submerged combustion burners useful in methods and systems of the present disclosure may be such that the flow of oxygen may range from about 0.9 to about 1.2 of the theoretical stoichiometric flow of oxygen necessary to obtain the complete combustion of the fuel flow. Another expression of this statement is that the combustion ratio may range from about 0.9 to about 1.2.

The velocity of the fuel in the burners of various method and system embodiments of the present disclosure depends on the burner geometry used, but generally is at least about 15 meters/second (m/s). The upper limit of fuel velocity depends primarily on the desired penetration of flame and/or combustion products into the glass melt and the geometry of the burner and melter; if the fuel velocity is too low, the flame temperature may be too low, providing inadequate temperature in the melter, which is not desired, and if the fuel flow is too high, flame and/or combustion products might impinge on a melter wall or roof, or cause carryover of melt into the exhaust, or be wasted, which is also not desired. Similarly, oxidant velocity should be monitored so that flame and/or combustion products do not impinge on a melter wall or roof, or cause carryover of melt into the exhaust, or be wasted. Oxidant velocities depend on fuel flow rate and fuel velocity, but in general should not exceed about 200 ft/sec at 400 scfh flow rate.

Additionally, burners useful in methods and system embodiments of this disclosure may also be provided with stabilization of the flame with an auxiliary injection of fuel and/or oxidant gases. For example, a portion of the oxidant may be premixed with fuel as a primary oxidant, usually air, in addition to a secondary oxidant injection.

Conduits, submerged combustion melter, luers, forehearth, channels, burners and the like useful in methods of the present disclosure may be comprised of metal, ceramic, ceramic-lined metal, or combination thereof. Suitable metals include stainless steels, for example, but not limited to, 306, 316, as well as titanium alloys, aluminum alloys, and the like. High-strength materials like C-110 and C-125 metallurgies that are NACE qualified may be employed. (As used herein, "NACE" refers to the corrosion prevention organization formerly known as the National Association of Corrosion Engineers, now operating under the name NACE International, Houston, Tex.) Use of high strength steel and other high strength materials may significantly reduce the wall thickness required, reducing weight for example of burners and melter walls. Threaded connections may eliminate the need for 3rd party forgings and expensive welding processes—considerably improving system delivery time and overall cost. It will be understood, however, that the use of 3rd party forgings and welding is not ruled out for certain burners useful in the methods described herein, and may actually be preferable in certain situations.

If ceramic materials are used, suitable materials may include fused zirconia (ZrO_2), fused cast AZS (alumina-zirconia-silica), rebonded AZS, or fused cast alumina (Al_2O_3). The choice of a particular material is dictated among other parameters by the chemistry, pressure, and temperature of fuel and oxidant used and type of glass melt to be produced.

The skilled artisan, having knowledge of the particular application, pressures, temperatures, vibrations, and available materials, will be able design the most cost effective, safe, and operable system components for each particular application without undue experimentation.

One or more control strategies may be employed, as long as the strategy includes measurement of melter system vibration and/or oscillation and those measurements (or values derived from those measurements) are used in predicting a melt property and/or controlling the melter system and/or controlling a downstream component or process. A combustion process control scheme may be employed, for example in conjunction with burner controllers 34, 36. A master controller may be employed, such as controller 48, but the disclosure is not so limited, as any combination of controllers could be used. Programmable logic controllers (PLCs) may be used.

Control strategies may be selected from proportional-integral (PI), proportional-integral-derivative (PID) (including any known or reasonably foreseeable variations of these), and may compute a residual equal to a difference between a measured value and a set point to produce an output to one or more control elements. The controller may compute the residual continuously or non-continuously. Other possible implementations of the disclosure are those wherein the controller comprises more specialized control strategies, such as strategies selected from feed forward, cascade control, internal feedback loops, model predictive control, neural networks, and Kalman filtering techniques.

Measurement of vibration is a well-developed science in its own right and requires little explanation to the skilled vibration sensor artisan. A good summary is provided by Furman, B. J., "Vibration Measurement", San Jose State University, Department of Mechanical and Aerospace Engineering, pp. 1-14, 22 Nov. 2005, incorporated herein by reference. Furman described vibration as interchange between potential and kinetic energy in bodies with finite stiffness and mass that arises from time dependent energy input, and gives examples, including fluid flow. Without being limited to any particular theory, the inventors herein theorize that the oxidant and/or fuel fluid flows through submerged combustion burners, and the flames and combustion products emanating from those burners, contribute to the vibration and/or oscillation observed in submerged combustion glass tank furnaces. Basic parameters of vibration study, such as amplitude, amplitude peak level, peak-to-peak amplitude, root-mean-square (RMS) amplitude level, and average (rectified) amplitude, are given schematically in FIG. 9A for a sinusoidal vibration, and in FIG. 9B for a more typical industrial vibration, from Furman.

Furman also summarizes vibration measurement transducers that may be useful in methods and systems of the present disclosure, for example, displacement-based sensors, velocity-based sensors, and acceleration-based sensors. Other sensors may be used. Examples of displacement-based sensors include linear variable differential transformer (LVDT) sensors, Eddy current sensors, capacitive sensors, and Hall sensors. Examples of velocity-based sensors include geophones and laser Doppler vibrometers. Examples of acceleration-based vibration sensors, perhaps more com-

monly referred to simply as accelerometers, include piezoelectric accelerometers, microelectromechanical systems (MEMS) accelerometers, and thermal accelerometers.

Sensors may be provided for burner controllers for the following parameters, which are merely exemplary examples: V_{fuel} , velocity of fuel entering burner; V_{PO} , velocity of primary oxidant entering burner; V_{SO} , velocity of secondary oxidant entering burner; M_{fuel} , mass flow rate of fuel entering burner; M_{PO} , mass flow rate of primary oxidant entering burner; T_{fuel} , temperature of fuel entering burner; T_{PO} , temperature of primary oxidant entering burner; P_{PO} , pressure of primary oxidant entering burner; H_{PO} , humidity of primary oxidant. Outputs may be provided for the following parameters, which are merely exemplary: V_{fuel} , velocity of fuel entering burner; V_{PO} , velocity of primary oxidant entering burner; M_{fuel} , mass flow rate of fuel entering burner; M_{SO} , mass flow rate of secondary oxidant entering burner; T_{fuel} , temperature of fuel entering burner; T_{PO} , temperature of primary oxidant entering burner; P_{SO} , pressure of secondary oxidant entering burner; M_{EFF} (or M_{HTE}), mass flow rate of hot effluent (or heat transfer fluid). Other parameters may be included as inputs, such as burner geometry, melter geometry, combustion ratio, melt viscosity, and the like.

Mathematical treatment of vibration and/or oscillation data, or any data collected as described herein, is straightforward. Transforms, such as Fourier and Inverse Fourier transforms, Laplace and Inverse Laplace transforms, Z-transforms and inverse Z-transforms, are known and explained in various textbooks and on the Internet. For example, see MathWorks.com. Any one or more of these mathematical treatments may be used to identify key frequencies, amplitudes, and the like.

An example of an equation that might be analyzed and used for predicting melt viscosity is Equation (1):

$$\eta=f(T, h, \omega, u, P, R) \quad (1)$$

where: η =melt viscosity, T =melt temperature, h =depth of glass in the melter, ω =frequency of vibration and/or oscillation of the melter, u =amplitude of vibration and/or oscillation of the melter, P =pressure in the melter, and R =melt flow rate from the melter. Non-limiting examples of other equations might be Equations 2-6:

$$\eta=f(T, \omega, u, P, R, V_{fuel}, V_{PO}, M_{fuel}, M_{PO}) \quad (2)$$

$$\eta=f(T, h, \omega, P, R, V_{fuel}, V_{PO}, M_{fuel}, M_{PO}) \quad (3)$$

$$\eta=f(T, h, \omega, u, P, R, \text{melter geometry}) \quad (4)$$

$$\Theta=f(T, h, \omega, u, P, R, \text{burner geometry}) \quad (5)$$

$$\rho=f(T, \omega, u, P, R) \quad (6)$$

where ρ is density of the melt. More than one equation may be employed, depending on the specific situation.

The term "control", used as a transitive verb, means to verify or regulate by comparing with a standard or desired value. Control may be closed loop, feedback, feed-forward, cascade, model predictive, adaptive, heuristic and combinations thereof. The term "controller" means a device at least capable of accepting input from sensors and meters in real time or near-real time, and sending commands directly to burner control elements, and/or to local devices associated with burner control elements able to accept commands. A controller may also be capable of accepting input from human operators; accessing databases, such as relational databases; sending data to and accessing data in databases, data warehouses or data marts; and sending information to

13

and accepting input from a display device readable by a human. A controller may also interface with or have integrated therewith one or more software application modules, and may supervise interaction between databases and one or more software application modules.

The phrase "PID controller" means a controller using proportional, integral, and derivative features. In some cases the derivative mode may not be used or its influence reduced significantly so that the controller may be deemed a PI controller. It will also be recognized by those of skill in the control art that there are existing variations of PI and PID controllers, depending on how the discretization is performed. These known and foreseeable variations of PI, PID and other controllers are considered within the disclosure.

The controller may utilize Model Predictive Control (MPC). MPC is an advanced multivariable control method for use in multiple input/multiple output (MIMO) systems. MPC computes a sequence of manipulated variable adjustments in order to optimise the future behavior of the process in question. At each control time k , MPC solves a dynamic optimization problem using a model of the controlled system, so as to optimize future behavior (at time $k+1$, $k+2$. . . $k+n$) over a prediction horizon n . This is again performed at time $k+1$, $k+2$ MPC may use any derived objective function, such as Quadratic Performance Objective, and the like, including weighting functions of manipulated variables and measurements. Dynamics of the process and/or system to be controlled are described in an explicit model of the process and/or system, which may be obtained for example by mathematical modeling, or estimated from test data of the real process and/or system. Some techniques to determine some of the dynamics of the system and/or process to be controlled include step response models, impulse response models, and other linear or non-linear models. Often an accurate model is not necessary. Input and output constraints may be included in the problem formulation so that future constraint violations are anticipated and prevented, such as hard constraints, soft constraints, set point constraints, funnel constraints, return on capital constraints, and the like. It may be difficult to explicitly state stability of an MPC control scheme, and in certain embodiments of the present disclosure it may be necessary to use nonlinear MPC. In so-called advanced control of various systems, PID control may be used on strong mono-variable loops with few or nonproblematic interactions, while one or more networks of MPC might be used, or other multivariable control structures, for strong interconnected loops. Furthermore, computing time considerations may be a limiting factor. Some embodiments may employ nonlinear MPC.

A feed forward algorithm, if used, will in the most general sense be task specific, meaning that it will be specially designed to the task it is designed to solve. This specific design might be difficult to design, but a lot is gained by using a more general algorithm, such as a first or second order filter with a given gain and time constants.

Although only a few exemplary embodiments of this disclosure have been described in detail above, those skilled in the art will readily appreciate that many modifications are possible in the exemplary embodiments without materially departing from the novel teachings and advantages of this disclosure. Accordingly, all such modifications are intended to be included within the scope of this disclosure as defined in the following claims. In the claims, no clauses are intended to be in the means-plus-function format allowed by 35 U.S.C. §112, paragraph 6 unless "means for" is explicitly recited together with an associated function. "Means for" clauses are intended to cover the structures described herein

14

as performing the recited function and not only structural equivalents, but also equivalent structures.

What is claimed is:

1. A method including feeding glass forming material into a melter, flowing an oxidant and a fuel into a submerged combustion burner positioned in the melter, the burner and melter defining a submerged combustion glass melting system producing molten glass, at least the melter having a variable vibration, the method comprising:

- a) measuring frequency and/or amplitude of the variable vibration of the melter;
- b) measuring oxidant flow rate, fuel flow rate, and glass forming material flow rate to the submerged combustion burner, and molten glass flow rate from the melter; and
- c) predicting a value of density of the molten glass using at least the measured frequency and/or amplitude of the variable vibration of the melter and the measured oxidant, fuel, glass forming material, and molten glass flow rates.

2. The method of claim 1 comprising measuring the depth or level of molten glass in the glass tank furnace, and using the measured depth or level in the predicting.

3. The method of claim 1 comprising feeding forward the predicted value of the at least one property to a controller controlling a process or component downstream of the glass tank melter into which at least a portion of the molten glass flows.

4. The method of claim 1 comprising using the predicted value of the at least one property to control the glass tank furnace.

5. The method of claim 1 comprising feeding forward the predicted value of the at least one property to a controller controlling a process or component downstream of the glass tank melter into which at least a portion of the molten glass flows and using the predicted value of the at least one property to control the glass tank furnace.

6. The method of claim 1 wherein the predicting comprises using a technique selected from the group consisting of linear regression, non-linear modeling, and neural net modeling.

7. A method of producing molten glass using submerged combustion, including feeding glass forming material into a melter, flowing an oxidant and a fuel into a submerged combustion burner positioned in the melter, the burner and melter defining a submerged combustion glass melting system producing molten glass, at least the melter having a variable vibration, the method comprising:

- a) measuring frequency and/or amplitude of the variable vibration of the melter;
- b) measuring oxidant flow rate, fuel flow rate, and glass forming material flow rate to the submerged combustion burner, and molten glass flow rate from the melter;
- c) predicting a value of viscosity of the molten glass using at least the measured frequency and/or amplitude of the variable vibration of the melter and the measured oxidant, fuel, glass forming material, and molten glass flow rates; and
- d) predicting a value of density of the molten glass using at least the predicted value of viscosity.

8. The method of claim 7 comprising measuring the depth or level of molten glass in the glass tank furnace, and using the measured depth or level in the predicting.

9. The method of claim 7 comprising feeding forward the predicted value of the at least one property to a controller

15

controlling a process or component downstream of the glass tank melter into which at least a portion of the molten glass flows.

10. The method of claim 7 comprising using the predicted value of the at least one property to control the glass tank furnace.

11. The method of claim 7 comprising measuring at least one other system property selected from the group consisting of glass tank furnace pressure, height or depth of molten glass in the glass tank furnace, and combinations thereof.

12. A method of making glass objects using submerged combustion, including feeding glass forming material into a melter, flowing an oxidant and a fuel into a submerged combustion burner positioned in the melter, the burner and melter defining a submerged combustion glass melting system producing molten glass, at least the melter having a variable vibration, the method comprising the steps of:

- a) measuring frequency and/or amplitude of the variable vibration of the melter;

16

- b) measuring oxidant flow rate, fuel flow rate, and glass forming material flow rate to the submerged combustion burner, and molten glass flow rate from the melter; and

- c) predicting a value of density of the molten glass using at least the measured frequency and/or amplitude of the variable vibration of the melter and the measured oxidant, fuel, glass forming material, and molten glass flow rates; and

- d) feeding forward the predicted value of the density to a controller controlling a process or component downstream of the melter for making glass objects.

13. The method of claim 12 wherein the process or component downstream of the glass tank melter is selected from the group consisting of a continuous glass fiber production system, a staple fiber attenuation system, and a system for producing shaped glass objects.

14. The method of claim 13 wherein the system for producing shaped glass objects comprises a system for producing foamed glass objects.

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